

Work Order ID 71934

Wednesday, July 13, 2011 12:55:48 PM



Page 1

Item ID: D4276-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Beam

Start Date: 7/13/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 11-07-13 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4276	A
-------	---

0.00
0.00
F.K. 11/07/25 4 0

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank TO 36.630"
Batch: 107221

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB007
DWG REV: A
FOLIO REV: AA

A.A. 11/07/27 4 0

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

130

QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

140

Chemical Conversion Coat per QS1005 4.1

0.00

HandFinish

Hand Finishing

Memo

0.00



B.A. 11/07/27

4

0

SL 11-07-28



1 p 11/07/28

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M117745. START. 2 IS

Powdercoat

Memo

OVENT. 320°

0.00

Powder Coating

MASK AS PER W/O

FINISH 2.45.

4 BR 11708

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 φ M 1107/25

180

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

18 11.07.29-

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/7/29 JG

11/07-29

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, July 13, 2011 12:55:45 PM

Page 1

Work Order ID: 71934

Parent Item: D4276-1

Parent Item Name: Aft Beam



Start Date: 7/13/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B
10.12.02 AS PER DWG REV.A DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased		No		100	f	26.3100	3.052	12.85053			



6061-T6 Bar 1.00 x 4.00



F.K- 11/07/26

Location	Loc Qty	Loc Code
MAT004	26.31	
<107221	22.23	
114352	2.58	
116808	1.5	

~~12.21~~ 9.158

M118400

3.062

* Please adjust mat in computer

B.A 11/07/27

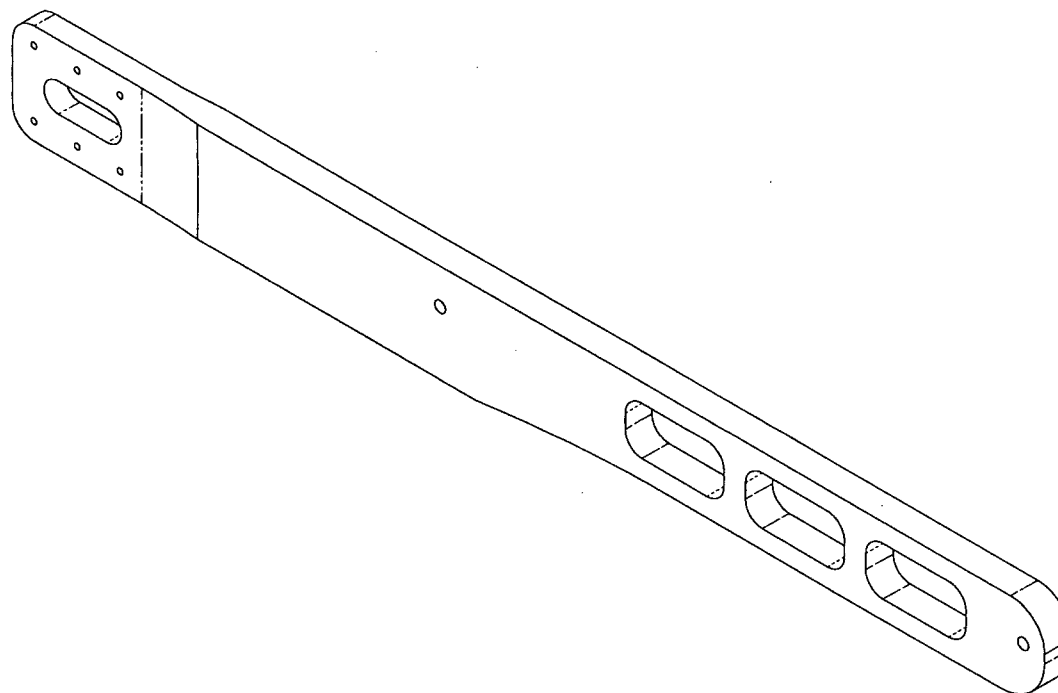
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D4276-1 AFT BEAM

#71934

RELEASE
2010-11-30

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.68 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A		NEW ISSUE		SC	10.11.25	
REV.		DESCRIPTION			BY	DATE
DESIGN		SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	JPH					
CHECKED	HA	DRAWING NO.			REV. A	
MFG. APPR.	HA	D4276			SHEET 1 OF 2	
APPROVED	HA	TITLE			SCALE	
DE APPR.	HA	AFT BEAM			NTS	
DATE	10.11.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

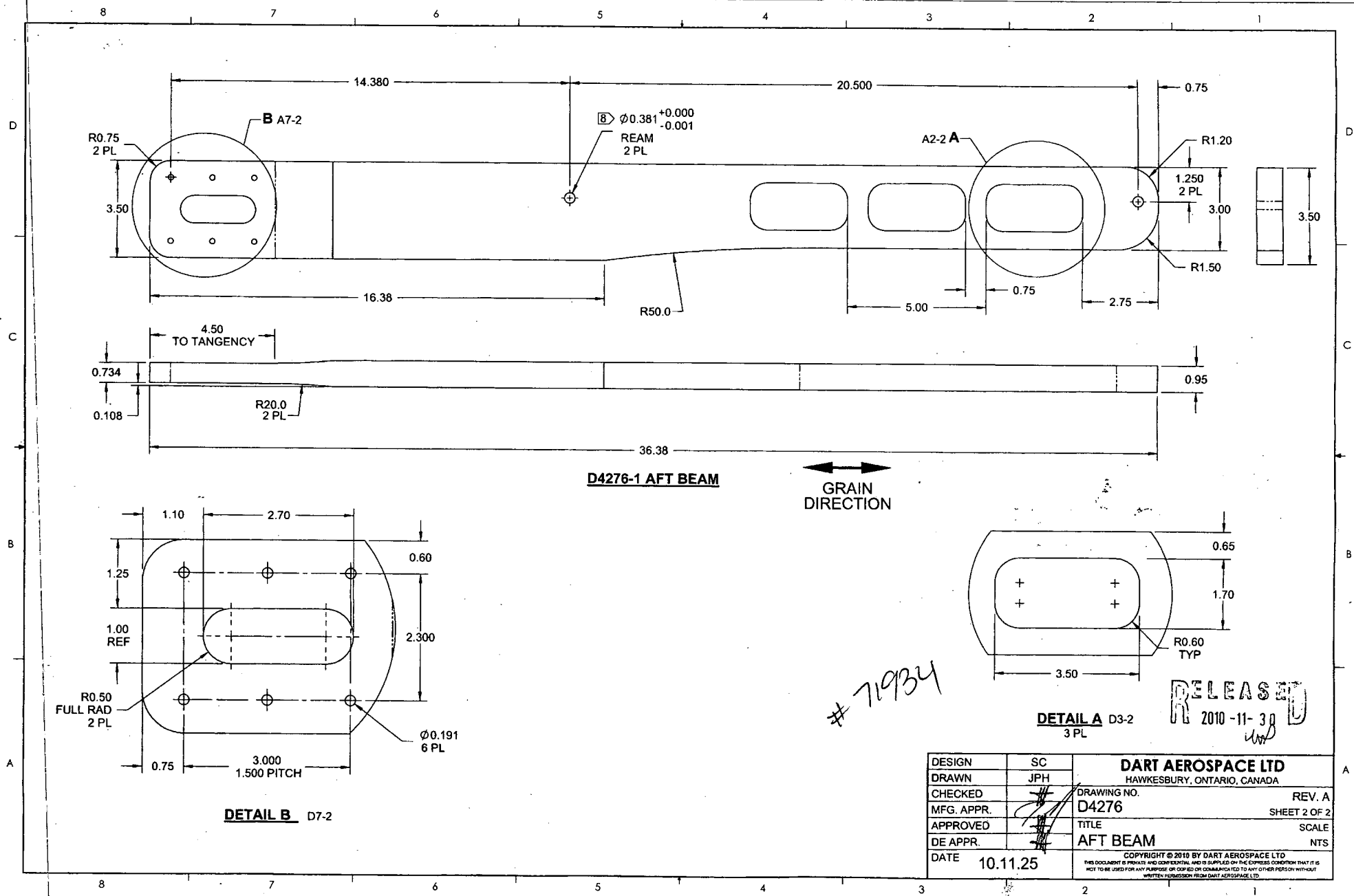
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71934

RELEASED
2010-11-30

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4276	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE AFT BEAM	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ORIGINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	10.11.25		

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DART AEROSPACE LTD		Work Order: 71934
Description: AFT BEAM		Part Number: D4276-1
Inspection Dwg: D4276 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/- .030	0.754	✓		Vern	GA-01
20.500	+/- .010	20.500	✓		Tape	GA-12
Ø 0.381	+0.000 / -0.001	Ø 0.381	✓		Mic	GA-03
14.380	+/- .010	14.380	✓		Tape	GA-12
R0.75	+/- .030	R0.750	✓		R-G	ref.
3.50	+/- .030	3.500	✓		Vern	GA-01
16.38	+/- .030	16.375	✓		Tape	GA-12
5.00	+/- .030	5.000	✓		Vern	GA-01
0.75	+/- .030	0.751	✓		"	"
2.75	+/- .030	2.751	✓		"	"
3.00	+/- .030	3.000	✓		"	"
1.250	+/- .010	1.249	✓		"	"
4.50	+/- .030	4.500	✓		"	"
0.734	+/- .010	0.735	✓		"	"
0.108	+/- .010	0.110	✓		H-G	31006
36.38	+/- .030	36.375	✓		Tape	GA-12
0.95	+/- .030	0.951	✓		Vern	GA-01
0.60	+/- .030	0.597	✓		"	"
2.70	+/- .030	2.695	✓		"	"
1.10	+/- .030	1.099	✓		"	"
1.25	+/- .030	1.251	✓		"	"
0.75	+/- .030	0.751	✓		"	"
3.000	+/- .010	3.000	✓		"	"

Measured by: D.A.	Audited by: JL	Preliminary Approval:
Date: 11/07/27	Date: 11-07-28	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

